Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1. (currently amended) A method of manufacturing a web-winding device, comprising the step of:

providing a generally cylindrical injection molded support structure having an outer web wrapping surface for receiving at least one convolution of a web and, an interior portion having an annular surface joined to the outer web wrapping surface, said outer web wrapping surface having a surface texture less than 0.5 microns Ra to produce a static coefficient of friction x_1 between the outer web wrapping surface and a first contact surface of said at least one convolution of web and a second contact surface of an at least a partial second convolution of said web produces a static coefficient of friction x_2, wherein x_1 is ~~less~~ greater than x_2.

2. (original) The method recited in claim 1 wherein said step of providing a generally cylindrical injection molded support structure further comprises the step of providing said outer web wrapping surface with a material selected from the group consisting of modified amorphous thermoplastic resins and semi-crystalline thermoplastic resins.

3. (currently amended) The method recited in claim 2 wherein said step of providing said outer web wrapping surface further comprises the step of providing said modified amorphous thermoplastic resin selected from the group ~~including~~ consisting of lubricated polycarbonate and silicone polycarbonate copolymers.

4. (currently amended) The method recited in claim 2 wherein step of providing a modified amorphous thermoplastic resin further includes the step of providing said semi-crystalline thermoplastic

resins with a material selected from the group ~~including~~ consisting of polybutylene-terephthalate, polybutylene-terephthalate/polycarbonate alloys and a modified polybutylene-terephthalate.

5. (original) The method recited in claim 4 wherein said step of providing said modified polybutylene-terephthalate further includes the step of providing said modified polybutylene-terephthalate with about 20 wt-% solid glass bead.